

Work Order ID 140648

Wednesday, January 13, 2016 7:19:05 AM

140648

Page 1

Item ID: D3916-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly

Start Date: 1/13/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/13/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLS Date: JAN 13 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100

0.00

100

Large Fab

Memo

0.05

Large Fab

- 1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
3- Trim access tube material to finish size as per dwg D3916
4- Drill and chamfer holes as per dwg D3916-1 using DT9605

6x CC 16-1-13

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

DAS

43

9-88

6xJAN 14 2016

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Page 2

Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 1/13/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/13/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107	Weld per dwg A/R S.S. rod Batch: B133750	0.00							
107									
Large Fab	Memo	0.03							
Large Fab	1- weld bushing as per dwg D3916 2- grind welds flush								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

6x **CC 16-1-14**

6x **DAS 43 9-89** **JAN 15 2016**

6x **DAS 43 9-89** **JAN 15 2016**

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Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 1/13/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/13/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WWA 04</u>	0.00						DAS	
130								43	
Packaging	Memo	0.00						9-89	JAN 15 2016
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

ML5 JAN 15 2016

Picklist Print

Page 1

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Work Order ID: 140648

140648

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 1/13/2016

Required Date: 1/13/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

82.0000

7

42

D3759-1

Bushing

CC 16-1-13

LocationLoc QtyLoc Code

WA004

82

138897

82

M304TS0.750W.049

Purchased

No

100

f

526.1588

4.166

26.31158

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

CC 16-1-13

LocationLoc QtyLoc Code

WA004

526.158768

M131868

1.104368

M132744

59.5184

M133417

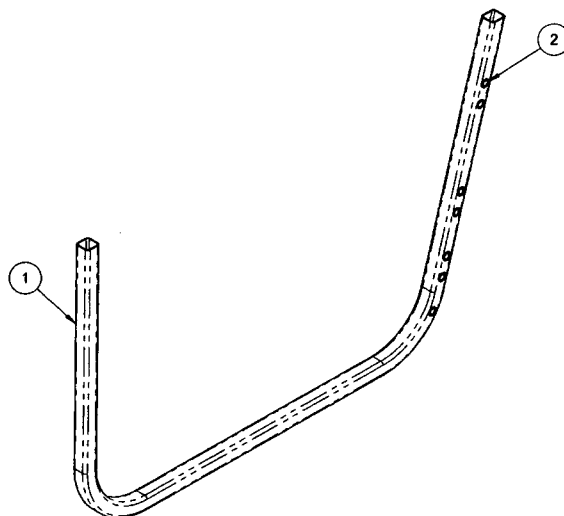
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M133762

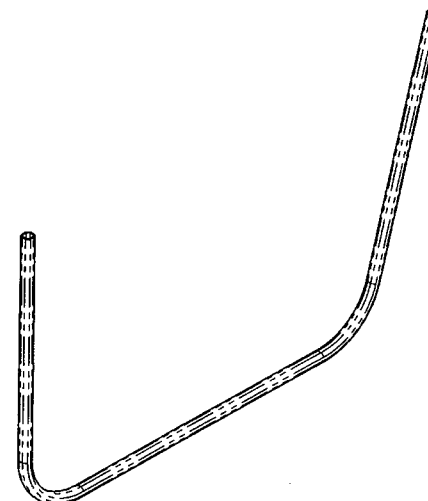
454

53

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

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UNCONTROLLED COPY
SUBJECT TO CHANGE

WITHOUT NOTICE
WORKS FOR

NO. 140648 M5
16-01-13

UNDER REVIEW

ADDITION OF HOLE + BUSHING
ON D3916-041-1 RIBS.

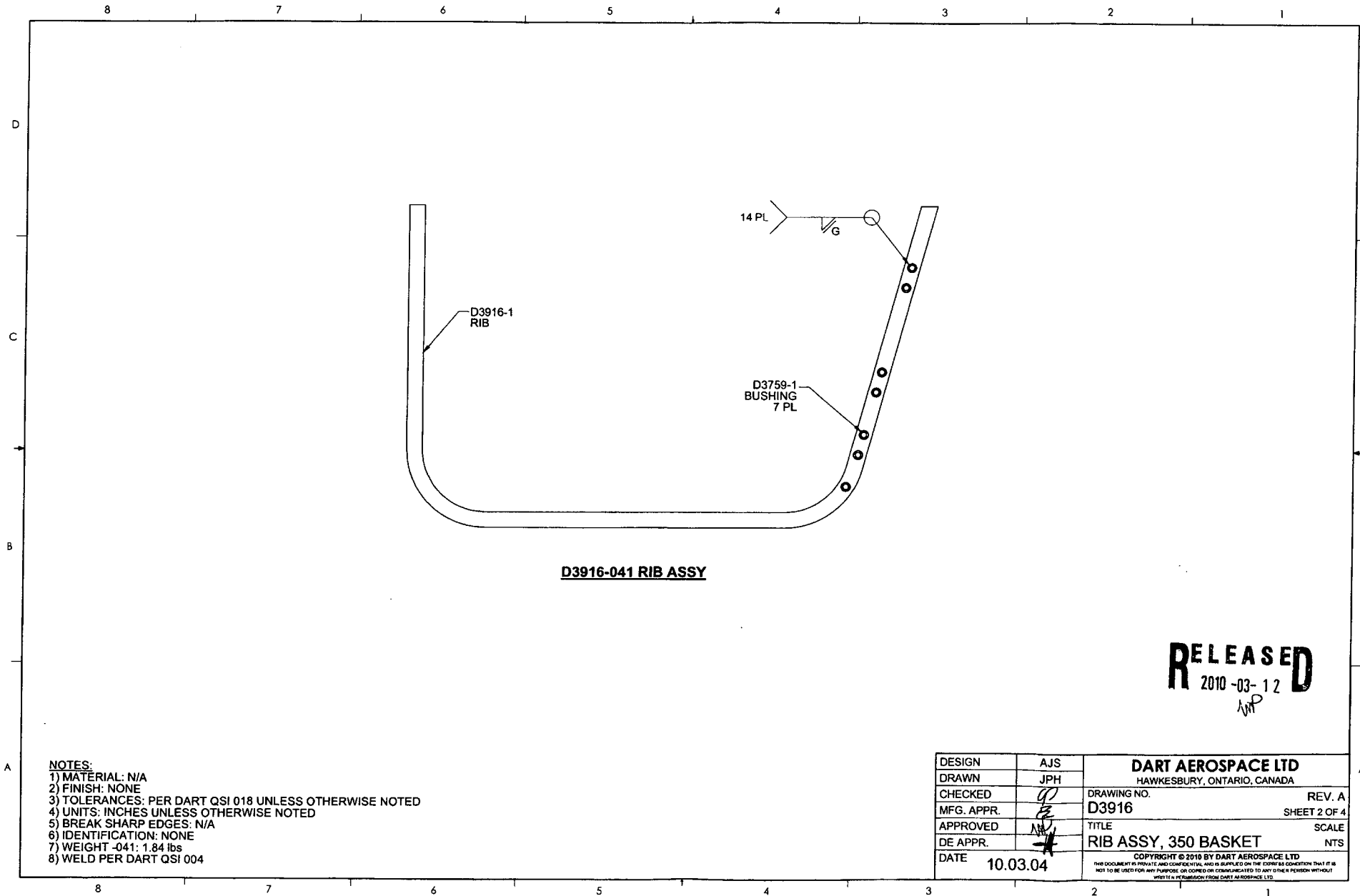
RELEASED
2010-03-12

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3916
REV. A
SHEET 1 OF 4
TITLE RIB ASSY, 350 BASKET
SCALE NTS

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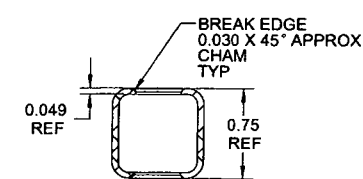
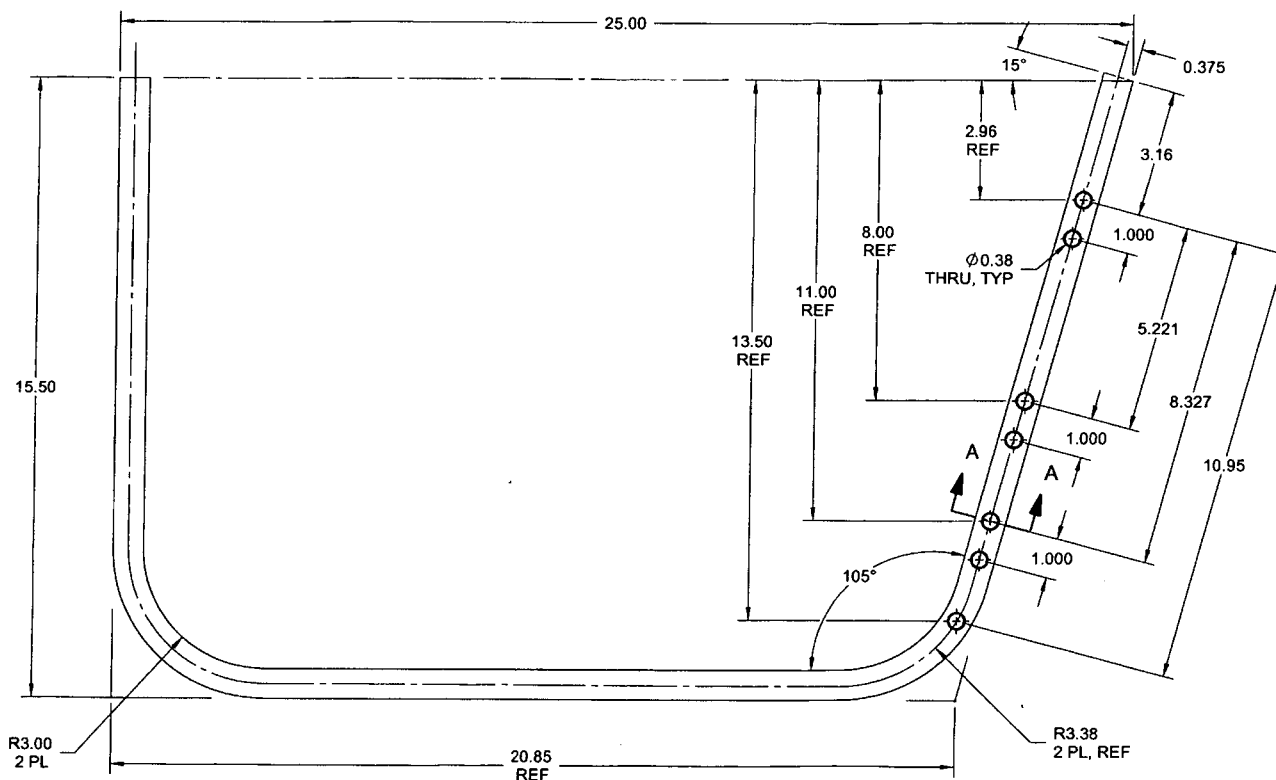


D3916-041 RIB ASSY

RELEASED
2010-03-12
AMP

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT -041: 1.84 lbs
 8) WELD PER DART QSI 004

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DRAWN	JPH		
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MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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SECTION A-A

9 D3916-1 RIB

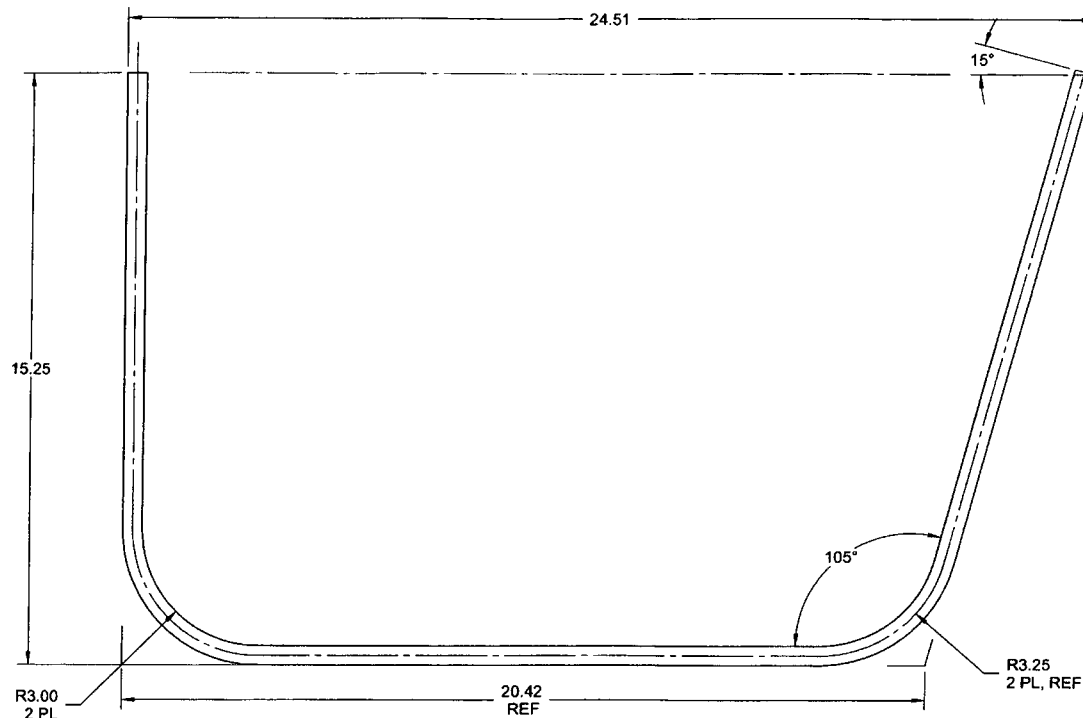
RELEASED
2010-03-12
NRP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

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9 D3916-5 LIGHT RIB



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2010-03-12
JPH

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

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